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RBE350A94-3700-A-1A

Job Sheet 197525



Part No: RBE350A94-3700-A-1A

Job Qty: 6 pcs

Part Name: Long Brace Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/10/19

Job Tracking No:

Due Date: 9/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-3700-A Rev 7 IPP Rev A 18.01.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	6 pcs	9/2/19		0.00	0.60	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	6 pcs	9/2/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
130	Packaging 3-1 - Stock - B4B	6 pcs	9/2/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS JUL 18 2019 40 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



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Container No: S198962



Part: RBE350A94-3700-A-1A

Job No: 197525

Serial No/Batch: S198962

Revision: 7

Inspector:

Exp Date:

Instructions:

Date: 07/18/19

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	6 pcs	9/2/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 110 - Small Fab-3 (Small Fab) -Assemble as per DWG. Sheet 2 -Loctite 262 B 5157322 Exp: 07/01/20 -See Descriptions: note 1

120 - QC5 (QC5- Inspect part completeness to step on W/O)

130 - Packaging3-1 (Identify as per dwg & Stock Location: _____)

140 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	12 Ea (2 ea)	110-Small Fab - 1	2180824
92905A225	Extended Point Set Screw, Dog Point	6 Ea (1 ea)	110-Small Fab - 1	5134216
CL-2-C	Lanyard Wire	7.8000 ft (1.3 ea)	110-Small Fab - 1	5190004
NAS1756-12	Remove Before Flight	6 Ea (1 ea)	110-Small Fab - 1	5165849
RBE350A94-3700-A-01	Tube	6 pcs (1 ea)	110-Small Fab - 1	5178035
RBE350A94-3700-A-03	Top	6 pcs (1 ea)	110-Small Fab - 1	5181360
RBE350A94-3700-A-05	Foot	6 pcs (1 ea)	110-Small Fab - 1	5147459

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	3896T31	12	519	0
	92905A225	6	62	0
	CL-2-C	8	1,241	0
	NAS1756-12	6	134	0
	RBE350A94-3700-A-01	6	8	0
	RBE350A94-3700-A-03	6	19	0
	RBE350A94-3700-A-05	6	9	0

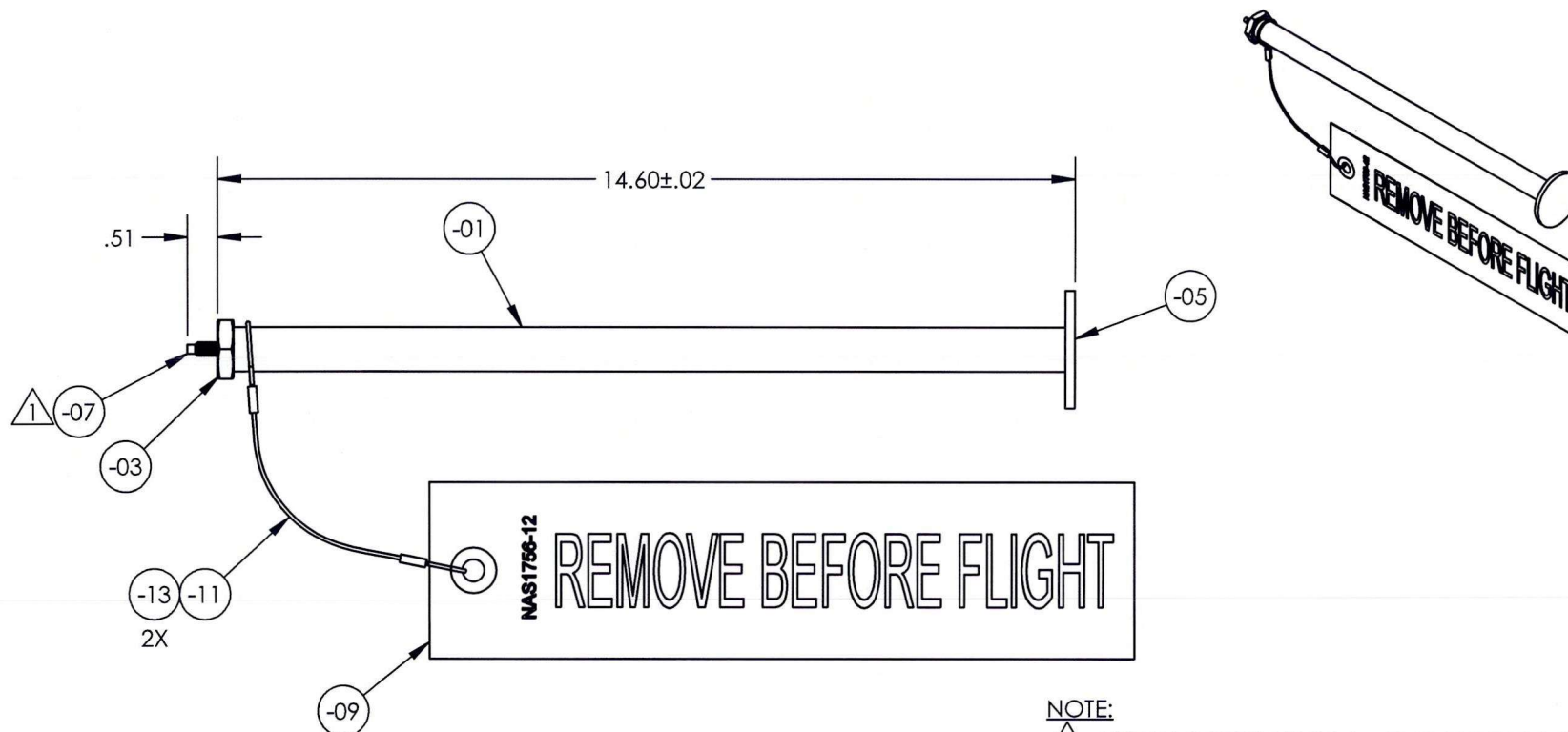
Part Specifications

Specifications could not be found.

Plex 7/10/19 8:36 AM Dart.lajeunesse.marie

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
7	16-0282	-1A ADDED TO BOM QTY: 3. ADDED DRAWING.			1/3/2017	DPD JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197525 MWS
19-07-10

NOTE:

1 APPLY LOCTITE 262 TO MATING THREADS OF
-03 CAP & -07 EXTENDED POINT SET SCREW,
DOG POINT.

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL LONG BRACE	
DWG NO. RBE350A94-3700-A-1A	REV 7
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: MACKOVJAK	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	EUROCOPTER AS350/355
SCALE 1:3	DATE 8/21/2012
	SHEET 2 OF 5

-1A

LONG BRACE ASSEMBLY

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			